Dart Aerospace Ltd. Thursday, 20/11/2008 3:35:21 PM Julie Dawson Hser **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : PLACARD Job Number : 43623 **Estimate Number** : 11149 P.O. Number **Part Number** : D32141 : 20/11/2008 This Issue S.O. No. : **Drawing Number** : D3214 REV B : NC Prsht Rev. **Project Number** : N/A First Issue : // : MACHINED PARTS **Drawing Revision** : B : 37103 **Previous Run** Material Due Date : 28/11/2008 Written By Qty: Each Checked & Approved By Comment A04.04.15 Est Rev:B Now 6061-T6 06-06-23 JLM **Additional Product** Job Number: Seq. #: Machine Or Operation: **Description:** 1.0 M6061T6S080 6061-T6 .080 Sheet 1.248 Comment: Qty.: -0.0780 sf(s)/Unit Total: 0.7802 sf(s) 5052-H32 .080 Sheet Material: 6061-T6 0.080" thick or 5052 H32 0.080" thick (M6061-T6S.080) or (M5052H32S080) Identify for D3214-1 Batch: M//0063 2.0 SHEAR SHEAR Comment: SHEAR Cut blanks: 3.70" x 2.70" Drill hole and fillet corner as per Dwg D3214 Deburr Identify as D3214-1 3.0 QC5 INSPECT WORK TO CURRENT STEP WORK TO CURRENT STEP 4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

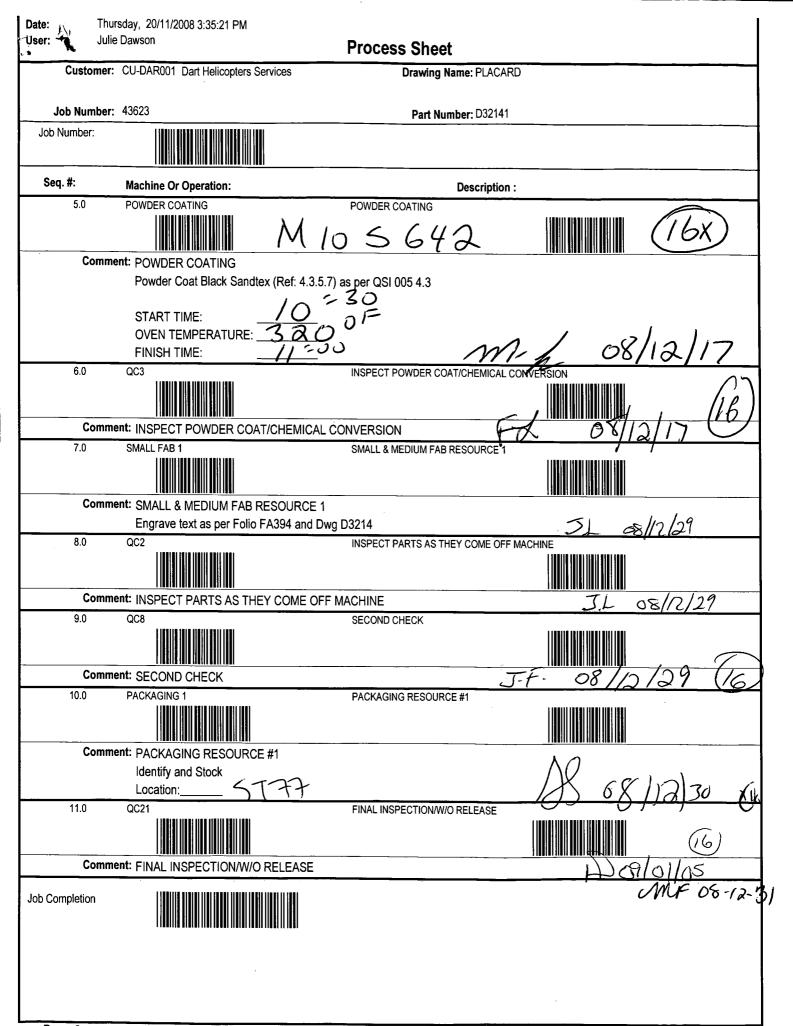
Chemical Conversion Coat as per QSI 005 4.1

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Dart Ae	rospace Ltd								
W/O:			WORK ORDER	CHANGES					
DATE	STEP	PF	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Category:	NCI	R: Yes	No DQ	A:	_ Date: _	
	Resolution	n:	Disposition:	QA:	N/C C	losed:		Date: _	
NCB:			WORK ORDER NON-CON	FORMANCE	(NC	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B				Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector			
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NOTE: Date & initial all entries



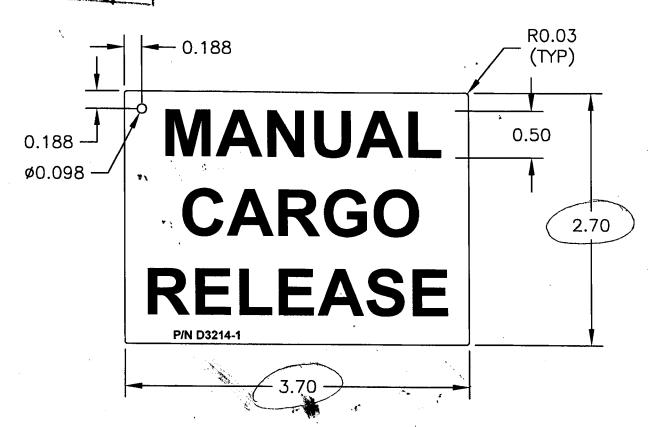
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		Description of NC		Corrective Action Section	on B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries



	DESIG	. 14	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECK		APPROVED #//	DRAWING NO. REV. B
		PH	90	D3214 SHEET 1 OF 1
1	DATE			TITLE SCALE
	06.0	5.29		PLACARD 1:1
	Α		04.01.27	NEW ISSUE
	В	. –	06.05.29	ADD 6061-T6 MATERIAL

RELEASED



NOTES

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)

0.080" THICK (REF DART SPEC M6061T6S.080)

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK SHOP COPY (REF DART SPEC M5052H32S.080)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

UNCONTROLLED COPY POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005st403CT TO AMENDMENT

3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT

WITHOUT NOTICE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

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